

SPLIT

PRELIMINARY ISSUE

Work Order ID 61885-1

Wednesday, September 08, 2010 3:28:31 PM



Page 1

Item ID: D4181-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Pod Frame Platform

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-9-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4181

PA1

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

MKT NOT PULLED

10-9-13

(3)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-9-13

Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61885

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Page 2

Item ID: D4181-1

Revision ID: PRELIM

Item Name: Pod Frame Platform

Start Date: 9/8/2010 Start Qty: 3.00

Accept



Setup Start



Stop



Required Date: 9/13/2010 Req'd Qty: 3.00



Cust Item ID:



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID
120

QC

Quality Control

Operation Description
QC8- Inspect parts - second checkSet Up/
Run Hours
0.00 - inspected to P21

Tool ID

Tool #

Plan Code
Due only

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

0.00 8/10/09/13 (x3)

124



Small Fab

Memo

0.00

0.00

Small Fab

Memo

1- C'sink holes as per dwg

126



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00 - inspected to P21

Due only

0.00 8/10/09/21 (x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61885

Wednesday, September 08, 2010 3:28:31 PM



Page 3

Item ID: D4181-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Pod Frame Platform

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID
130

HandFinish

Operation Description
Chemical Conversion Coat per QSI005 4.1Set Up/
Run Hours
0.00Tool ID
=JUTool #
10/09/21Plan
CodeAccept
Qty
X3Reject
Qty
0Reject
Number
X3Insp.
Stamp

Memo

0.00

140



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

=JU

10/09/22

X3 0

Memo

0.00

Start Time: 6:30AM
Oven Temperature: 320° F
Finish Time: 7:00PM

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

FT 10-09-22 Y3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61885

Wednesday, September 08, 2010 3:28:31 PM



Page 4

Item ID: D4181-1

Revision ID: PRELIM

Item Name: Pod Frame Platform

Start Date: 9/8/2010 Start Qty: 3.00

Accept



Setup Start



Stop



Required Date: 9/13/2010 Req'd Qty: 3.00



Cust Item ID:



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

CD

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

Memo

Y2W

0.00

BT 10 09 25 QL

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/29 JJ

W 10-09-23

POSITIVE RECALL

EFFECTIVE 10.09 AUTH U

RELEASED DATE 10.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 08, 2010 3:28:36 PM

Page 1

Work Order ID: 61885



Parent Item: D4181-1



Parent Item Name: Pod Frame Platform

Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250 		Purchased		No		100	sf	0.0000	0.653	2.062105	3.	18/10-9-13	

6061T6S.250

6061 T6B 250x6.000

M115212

M115212

(3)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

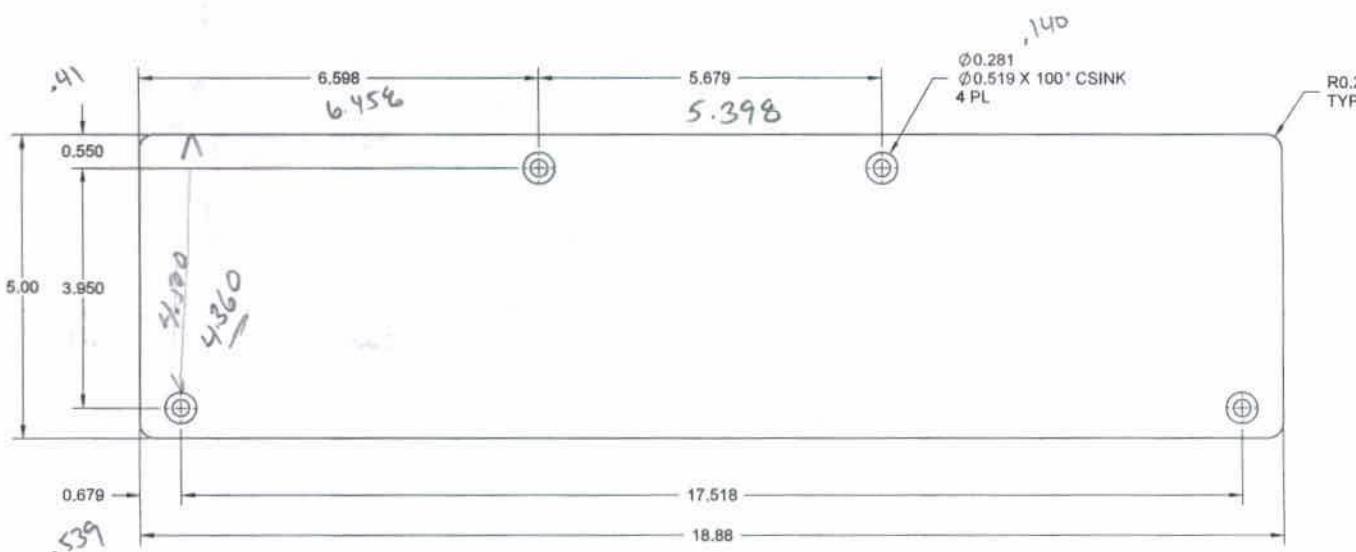
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Route/Ban/ABF
Done

8 7 6 5 4 3 2 1

D



D4181-1 POD FRAME PLATFORM

A
NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.250 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.29 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WHEN ISSUED
V
NO. 61885
PL 10-909

PRELIMINARY ISSUE
10.09.03

PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			DART AEROSPACE LTD
DRAWN			HAWKESBURY, ONTARIO, CANADA
CHECKED			DRAWING NO. REV. PA1
MFG. APPR.			D4181 SHEET 1 OF 1
APPROVED			TITLE SCALE
DE APPR.			POD FRAME PLATFORM NTS
DATE	10.09.03		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUBJECT TO THE EXPRESS CONDITIONS SET FORTH HEREIN. IT MAY NOT BE COPIED OR DISSEMINATED FOR ANY PURPOSE OTHER THAN THOSE PROVIDED HEREIN. DART AEROSPACE LTD

DART AEROSPACE LTD	Work Order:	61885
Description: Pod FRAME PLATFORM	Part Number:	D4181-1
Inspection Dwg: D4181-1 Rev: P41		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-13	Date:	10/09/13	Date:	N/A
		Inspector to PGI Day on 4			
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	

